

DUPLICATE

Dart Aerospace Ltd.

Date: Tuesday, 22/05/2007 11:31:11 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HOUSING WELDMENT
Job Number : 32219	
Estimate Number : 11874	
P.O. Number : <i>N/A</i>	Part Number : D2207041
This Issue : 22/05/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2207 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 03/05/2007 Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/05/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>6</i> Um: Each
Comment : Est. C 01.10.18 Added Step 10 and 11 SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2208	End Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

End Cap

Pick:

Qty	Part Number	Description
2	D2208	End cap

Batch

13261 x4 4510 x8 FC 07 05 23 (6)

2.0	D22071	Housing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Housing

Pick:

Qty	Part Number	Description
1	D2207-1	Housing

Batch

15242 FC 07 05 23 (6)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D2207

Grind welds flush as per Dwg D2207

Ph. FC

07.05.23

07 05 23 (6)

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

107/05/24 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070824	3.0	Parts were made to Rev. B. No gage, and weld crack	QSIWZ	Scrap, destroy, no replace. Another W/O was issued at rev. C. B33982 → see W/O	Am 07/08/27	SB 07/08/27	QSIWZ	070824

NOTE: Date & initial all entries

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Drawing Name: HOUSING WELDMENT

Job Number: 32219

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Drill holes using DT8557 as per Dwg D2207

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

ALS71032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Insert

Qty Part Number Description Batch

4 DAK57-1032-130 Insert

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Install AK57-1032-130 as per Dwg D2207

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: HOUSING WELDMENT

Job Number: 32219

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

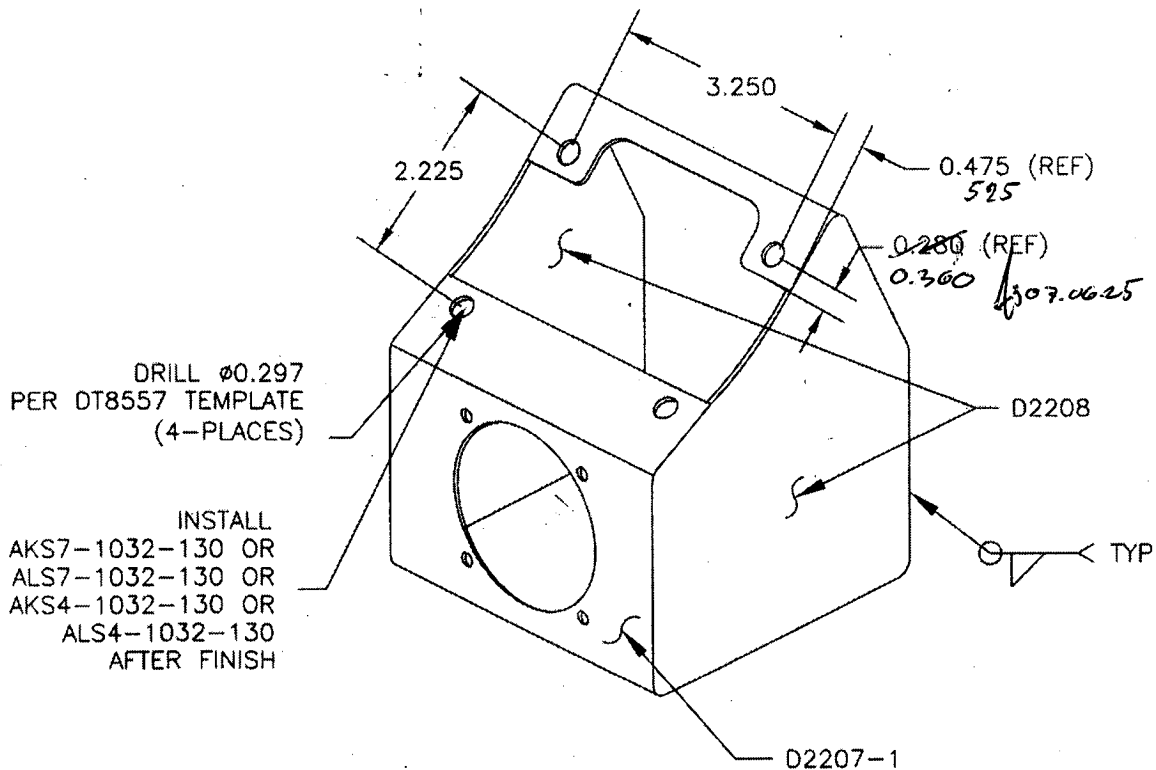
NOTE: Date & initial all entries

Total: 3.775
(3.250 + .525)

3.775

SIGN KF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED J	APPROVED S	DRAWING NO. D2207	REV. B SHEET 1 OF 2
DATE 01.02.23	TITLE HOUSING		SCALE 1:2
	94.09.01	NEW ISSUE	
	01.02.23	REDRAWN	

Wp 32249



D2207-041 ASSEMBLY

2208
2207-1

NOTE:



- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT CLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

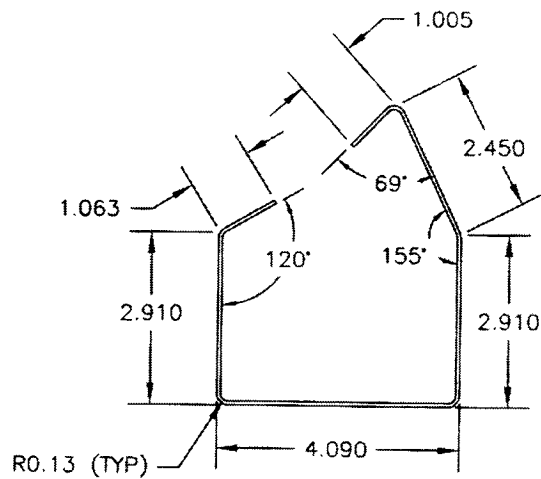
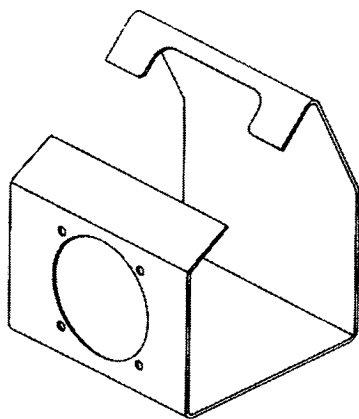
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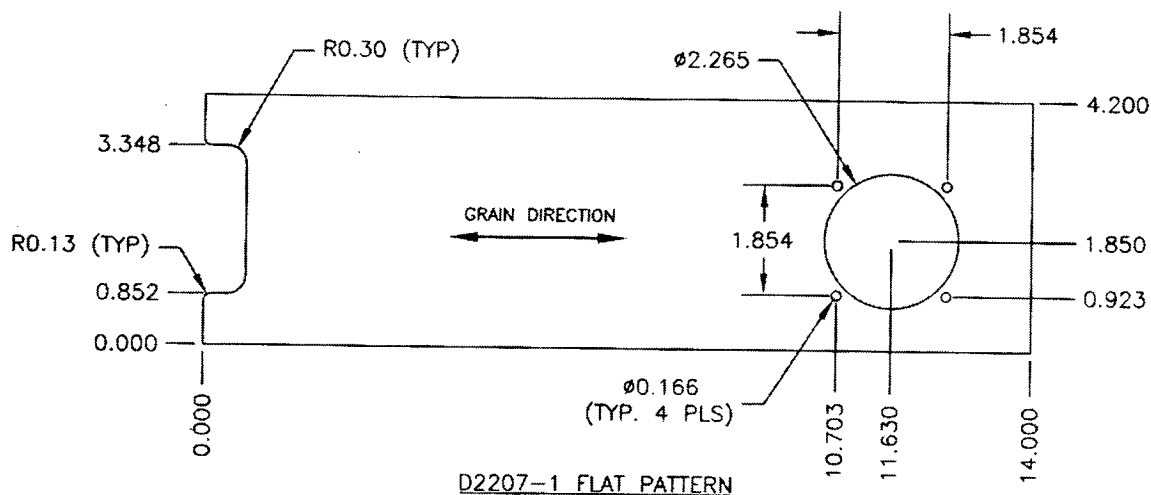
QA COPY ISSUED

9.07.27 ~~A~~

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	D2207
DATE	01.02.23	TITLE	HOUSING	REV. B	SHEET 2 OF 2
				SCALE	1:3



D2207-1 BENDING DETAIL



D2207-1 FLAT PATTERN

MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) ALUMINUM 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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